

Work Order ID 111897

111897

Page 1

Monday, January 27, 2014 8:19:50 AM

Item ID: D2855 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cap
Start Date: 1/27/2014 Start Qty: 25.00 ~~*25*~~ **(50)** Cust Item ID:
Required Date: 2/19/2014 Req'd Qty: 25.00 ***25*** Customer:
Reference:

Approvals: Process Plan: CL Date: 14/01/27 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	Rev B								
100	PURCHASING	0.00							
100									
Purchasing	Memo 22985	0.00							
Purchasing	Issue P/O: 22743 Cast per Dwg D2855 Material Release Note Required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

CL 14/02/12 50
~~CL 14/01/27 25~~

CL 14/4/11 (50)

DAS
27
9-89

14/4/12

50

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Stop *NR2*

**Insp.
Stamp**

1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"- Debur

Quality Control

Powder Coating

Memo

~~START TIME:~~

FINISH TIME:

0.00

• ~~OVEN~~ TEMPERATURE:

OVEN TEMP 910

DAS 34 9.80

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Item ID: D2855 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cap
Start Date: 1/27/2014 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 2/19/2014 Req'd Qty: 25.00 ***25*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						x50	φ	ll	1/10/10
QC	Memo	0.00							
Quality Control									
170	Small Fab	0.00							
170						x50	φ	ll	1/10/10
Small Fab	Memo	0.00							
Small Fab	Install Inserts as per Dwg D2855								
180	QC5- Inspect part completeness to step on W/O	0.00							
180						50	φ	14-4-10	
QC	Memo	0.00							
Quality Control									

DAS 34 9-89

Work Order ID 111897***111897***

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Monday, January 27, 2014 8:19:50 AM

Item ID: D2855

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 1/27/2014 Start Qty: 25.00

25

Cust Item ID:

Required Date: 2/19/2014 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: FP-001

0.00

190

Packaging

Memo

0.00

Packaging

X50 g all 1/26/14

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

14-04-14(H) 14-04-11

Picklist Print

Monday, January 27, 2014 8:19:49 AM

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Work Order ID: 111897

Parent Item: D2855

Parent Item Name: Cap

Comments: IPP: B00.06.22Added receiving step & removed P/O for powder coat EC

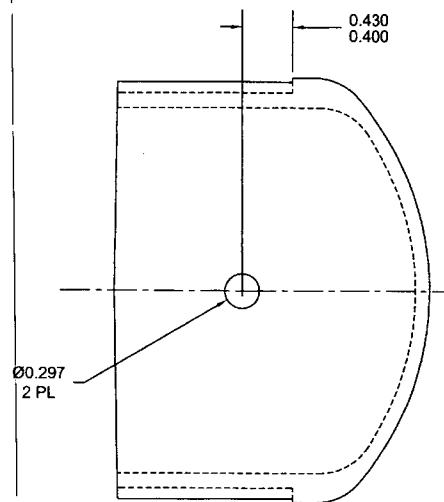
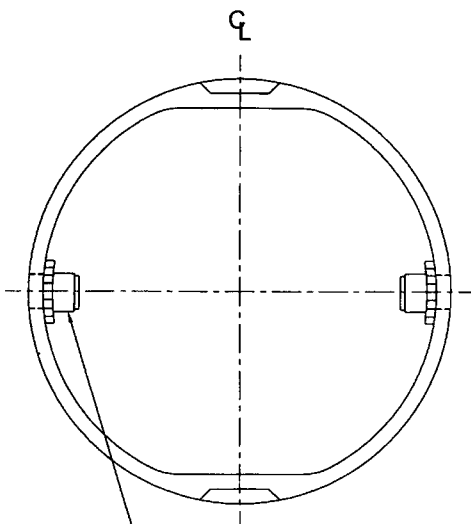
Start Date: 1/27/2014

Required Date: 2/19/2014

Start Qty: 25.00

Required Qty: 25.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225 Insert		Purchased	No			100	Each	80.0000	2	50 100		14/04/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		80		M128679		✓100			
				118520		80							
D2855P Cap		Purchased	No			170	Each	0.0000	1	25		14/4/14	(50)



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

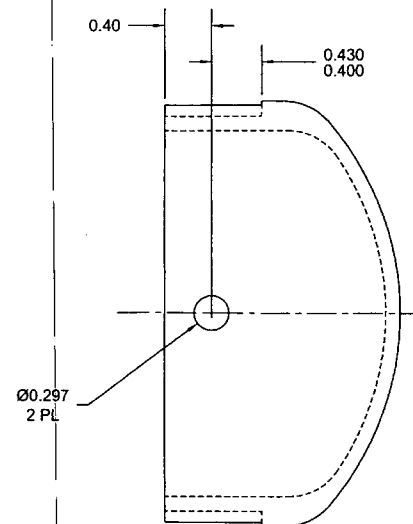
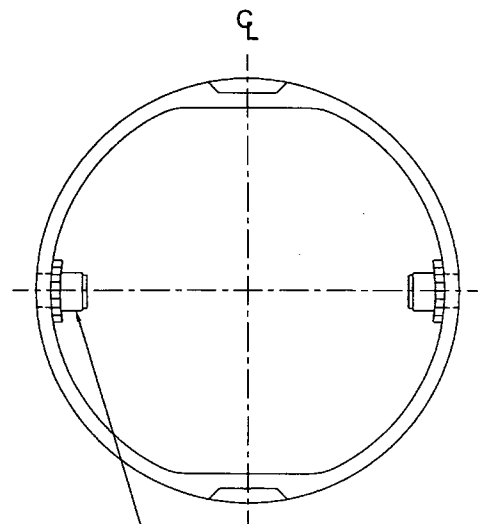
D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
21/07/19


NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

RELEASED
24/1/13 MB

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22985

Purchase Order Date 2/12/2014

PO Print Date 2/12/2014

Page Number 1 of 1

Order From :

VC-MSY01

Ship To : DART AEROSPACE LTD

METALLURGIE SYCA
500 PRINCIPALE

ST.DOMINIQUE, QUEBEC JOH 1LO

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 450-261-0853

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P Tooling to be supplied Manufacture as per drawing D2855 rev.B B111897	Cap	3/3/2014 Yes 3/3/2014		50.00 Each	\$8.80	\$440.00

Line Total: \$440.00

2	D2855P Tooling to be supplied. Manufacture as per drawing D2855 rev.B B111898	Cap	3/3/2014 Yes 3/3/2014		50.00 Each	\$8.80	\$440.00
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Line Total: \$440.00

PO Total: \$880.00

PO Instructions: PROCUREMENT QUALITY CLAUSES

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM

M. L...

Invoice

05/03/2014

19400

Sales Rep. : LASZLO VARGA
Order : 11469
Reference : PO22985

Customer : 6325200

Ship To :

DART AEROSPACE LTD
 1270, ABERDEEN STREET
 HAWKSBURY, ONTARIO
 K6A 1K7

Same

Tel.: 613 632-9677

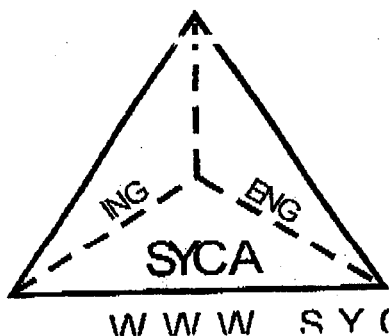
Item No.	Description	Ordered	Inv.	B-O	Price	Total	Tx
D-2855	CAP D-2855	100	102	0	8.8000	897.60	A

SHIPPING MEMO #931125
 VIA FEDEX PI COLLECT

ORDER COMPLETED
 THANKS FOR YOUR SUPPORT

COPY **Subtotal :** 897.60
 TVH ON : 116.69
 Total : 1 014.29

A) Regist : 873216006RT0001



MÉTALLURGIE SYCA Inc

500, Principale
St-Dominique, Québec
J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

WWW SYCA - INC COM

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2014-03-31

SHIPPING MEMO: 931125

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	102 <i>50</i>	D-2855	11469

All item specify in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ28022014

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

RESPONSIBLE: CARL JOBIN ING.

SA-101

ROUVILLE STATION INC.
1032, BOUL. RICHELIEU
RICHELIEU (QUÉBEC)
J3L - 0L7

TEL: (450) 658-2183

TEL: (450) 658-2808

FAX : (450) 658-1461

Coulée	# 114
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ELEMENT:

ALLIAGE

[356.2]

A 356.1

ANALYSE MOYENNE

CHEF DE LABORATOIRE :

Date : 11-13-2013